

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026094**Date Inspected:** 10-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds located on OBG13E that was previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. The following issue(s) have been noted and this QA Inspector provided a turnover to dayshift personal for tracking of these welds. The weld designations reviewed are as follows:

VP3008-001-001,014,028

VP3007-001-023,036,049,062,075

SEG3007P-002,077

SEG3007B-157,171

DP3082-001-069,070,073,074,

FB3101-001-045,046,047,048,049,050,051,052,

FB3104-001-025,026,027,028,029,030,031,032,033,034,035,036

FB3102-001-034,035,036,037,038,039,040,041

FB3113-001-009,010,011,012,013,014,015,016

FB3114-001-046,047,048,049

FB3116-001-013,014,015,016,017,018,019,020

SEG3007AT-336,337,338,339,340,341,342,343,376,377,378,379,380,381,382,383

SEG3014L-151,152,157,158,163,164,169,170,175,176,181,182,187,188,147,148,153,154,159,160,165,166,171,
172,177,178,183,184

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SEG3014B-203,221,222
SEG3014D-231
SEG3014P-229
SEG3015K-268

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13E. The weld designations reviewed are as follows:

VP3008-001-001,014,028
VP3007-001-023
FB3104-001-025,026,027,028,029,030,031,032,033,034,035,036

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds located on OBG13W that was previously tested by American Bridge Fluor (ABF) QA personnel using the Magnetic Particle (MT) and VT method. The following issue(s) have been noted and this QA Inspector provided a turnover to dayshift personal for tracking of these welds. The weld designations reviewed are as follows:

SEG3013C-200,201,205,206,210,211,215,216,220,221,225,226
FB3202-001-103,104,108,109,113,114,122,123,129,130,136,137

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13W. The weld designations reviewed are as follows:

FB3202-001-129,130,136,137
SEG3013C-200,201,205,206

During random in-process visual inspection of welds located in OBG13E, this Quality Assurance Inspector (QA) observed under size welds in an area previously inspected and accepted by ZPMC and AB/F. This QA informed ZPMC QC Zhung Wei of this condition. The area is located on SEG3013C and identified as weld numbers 201, 206 and 226. A TL-015 Incident Report will be documented for the accordance. (See Photos below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer